

5/44

DART AEROSPACE LTD	Work Order:	24626
Description: Hinge Bracket	Part Number:	D2857-2
01.08.17 <i>MD</i> 04.08.17 <i>GP</i>		
Drawing: D2857 Rev. A1	Qty:	24

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Open W/O	<i>MD</i>	05.10.21	24
2	METAL	Cut blanks 5.2" Material: 2.00" X 1.25" 6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8) Batch 115818	<i>BG</i>	05.11.02	24
3	HAAS	Machine per folio D2857-2	<i>MB</i>	05.11.14	24
4	QC	Inspect Level 2	<i>BG</i>	05.11.05	24
5	METAL	Tumble N/A Deburr any rough edges after tumbling	<i>BG</i>	05.11.05	24
6	METAL	Acid etch and alodine as per QSI 005 4.3	<i>MD</i>	05.11.16	24
7	QC	Inspect Level 7	<i>MD</i>	05.11.16	24
8	FINISHING	Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3	<i>MD</i>	05.11.16	24
9	QC	Inspect Level 3	<i>MD</i>	05.11.16	24
10	STORES	Identify and stock	<i>MD</i>	05.11.16	24
11	EXPEDITING	Close W/O Cost / Part: <i>24.16 SAC 05/11/21</i> <i>24</i>	<i>MD</i>	05.11.21	24

Rev	Date	Change	Revised By	Approved
A	99.01.04	New	KS	
B	99.03.25	Added tumble and acid etch	DM	
C	00.06.22	Removed P/O for powder coat	EC	

RELEASED
JUN 26 2000
EC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: 19 Date: 05/11/21

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	24626
Description: Hinge Bracket		Part Number:	D2857-2
Inspection Dwg: D2857 Rev: A1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.310"	✓			
0.340	+/-0.010	.339"	✓			
1.110	+/-0.005	1.110"	✓			
1.790	+/-0.010	1.790"	✓			
1.320	+/-0.005	1.318"	✓			
2.000	+/-0.010	2.004"	✓			
Ø0.171	+0.005/-0.000	Ø0.171"				
0.147	+/-0.010	.144"	✓			
0.376	+/-0.010	.375"	✓			
0.126	+/-0.010	.128"	✓			
0.611	+/-0.010	.615"	✓			
0.063	+/-0.010	.067"	✓			
0.166	+0.005/-0.000	.166"	✓			
0.911	+/-0.010	.917"	✓			
0.600	+/-0.010	.609"	✓			
0.125	+/-0.010	.125"	✓			
0.150	+/-0.010	.148"	✓			

Measured by: MB	Audited by: En	Prototype Approval:	N/A
Date: 05/11/04	Date: 05/11/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	

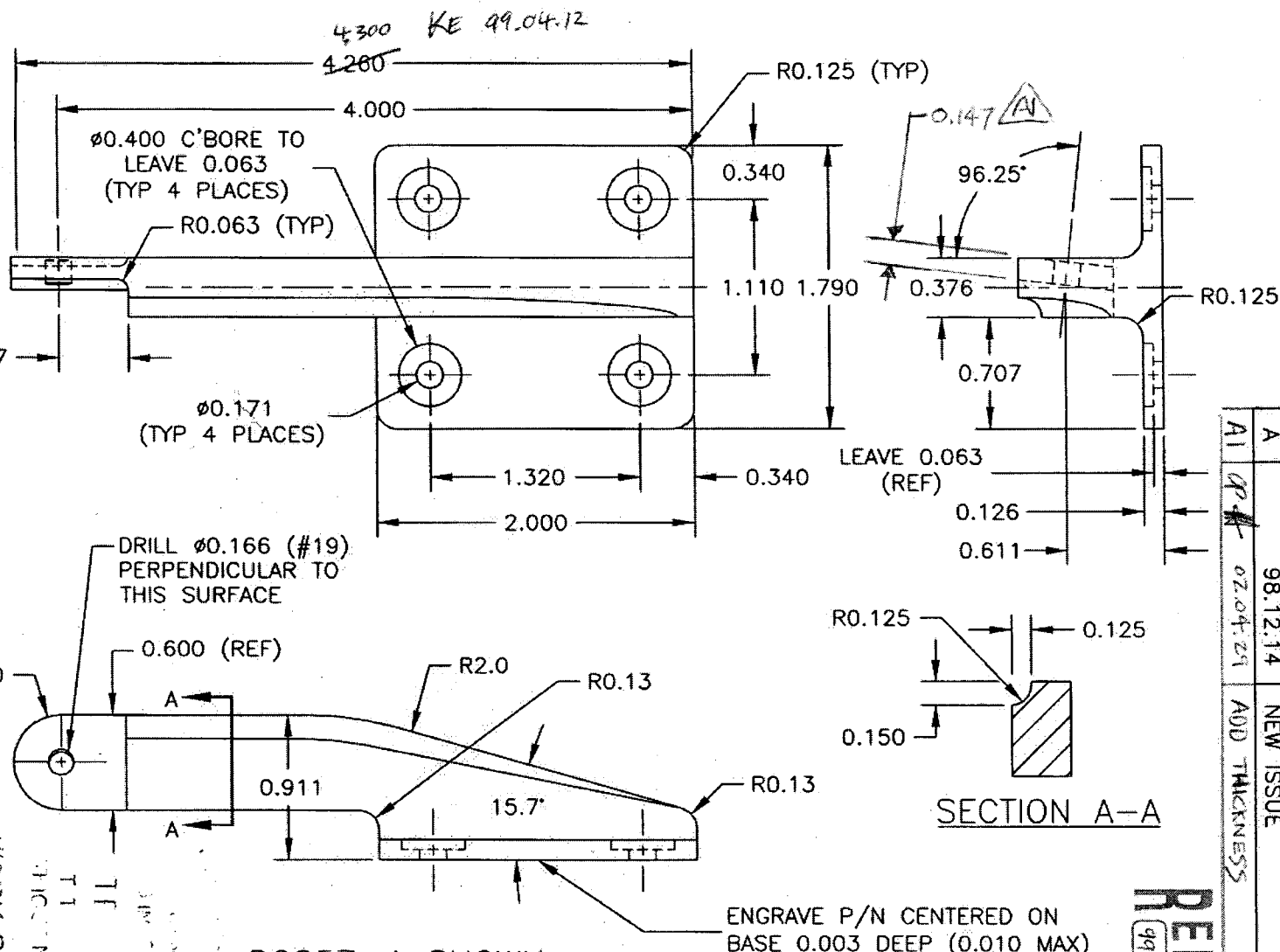
RELEASED
04.06.17

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	SP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	SP	D2857
DATE	TITLE	REV. A
98.12.14	HINGE BRACKET	SHEET 1 OF 1
A	NEW ISSUE	SCALE 1:1
AI	ADD THICKNESS	

RELEASED
99.01.06 KE



D2857-1 SHOWN
D2857-2 OPPOSITE

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)
FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

WORK ORDER
NO. 24626

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 20, 2005
04:09 pm

Work Order No : 0024626
Project Name : D2857-2
Project For : WK544
Work Order Type : Main
Main WO Number :
House Part Number : D2857-2
Description : Hinge Bracket
Manufactured : Yes
Amount Req'd : 24
Amount Done : 0
Start Date : 10-20-05
Est Finish Date : 11-03-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
12:41 pm

Work Order No : 0024626
Project Name : D2857-2
Project For : WK544
Work Order Type : Main
Main WO Number :
House Part Number : D2857-2
Description : Hinge Bracket
Manufactured : Yes
Amount Req'd : 24
Amount Done : 0
Start Date : 10-20-05
Est Finish Date : 11-03-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	9.50	100.00		
Production Cost :	0.00	226.61	100.00	0.00	226.61
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	9.00	100.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	226.61	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	226.61			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	(-226.61)

MIS D/B
w
11-13

Date: Monday, 14/11/2005 8:10:59 AM
 User: Alba Panzulo

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HINGE BRACKET
Job Number	: 24626		
Estimate Number	: 10347		
P.O. Number	:	Part Number	: D28572
This Issue	: 14/11/2005	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2857 REV A1
First Issue	: / /	Project Number	:
Previous Run	: 24502	Drawing Revision	: A1
	Type : MACHINED PARTS	Material	:
Written By	:	Due Date	: 30/11/2005
Checked & Approved By	:	Qty:	24 Um: Each
Comment	: Est C 00.06.22 Removed P/O for powder coat EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B2000X01250	6061-T6 Bar 2.0" x 1.25"
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2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks 5.2"

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine per folio D2857-1

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 1-Tumble
 2-Deburr any rough edges after tumbling

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Acid etch and Alodine as per QSI 005 4.3

Date: Monday, 14/11/2005 8:10:59 AM
User: Alba Panzuto

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 24626

Part Number: D28572

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

